

Work Order ID 67503

Wednesday, March 23, 2011 12:43:21 PM



Page 1

Item ID: D3065-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Leg Assembly Hi

53

Start Date: 3/23/2011

Start Qty: 50.00



Cust Item ID:

Required Date: 3/24/2011

Req'd Qty: 50.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-03-23

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3065

Rev B

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D3065 and Identify as D3065-041

4/5/11/03/29 53

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5/11/03/30

counts

53

120

Identify as per dwg & Stock Location: WPA

0.00



Packaging

Memo

0.00

Packaging

11.04.29

53

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Stop



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Start Date: 3/23/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 3/24/2011 Req'd Qty: 50.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/39

11-04-29
(53)

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 67503

Parent Item: D3065-041

Parent Item Name: Step Leg Assembly Hi





Start Date: 3/23/2011

Required Date: 3/24/2011

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev: C02.11.01 Incorporated D3066-1 IPP KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3065-1  Step Spacer		Manufactured	No			100	Each	69.0000	1	50			
<div> <div>Location</div> <div>GA</div> <div>65549</div> <div>67220</div> </div> <div> <div>Loc Qty</div> <div>69</div> <div>30</div> <div>39</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div> <div> <div>30</div> <div>23</div> </div>													
D3065-3  Step Spacer		Manufactured	No			100	Each	23.0000	1	50			
<div> <div>Location</div> <div>GA</div> <div>48113</div> <div>65551</div> </div> <div> <div>Loc Qty</div> <div>23</div> <div>10</div> <div>13</div> </div> <div> <div>Loc Code</div> <div>B67221</div> <div></div> <div></div> </div> <div> <div>37</div> <div>13</div> </div>													
D3065-5  Step Leg		Manufactured	No			100	Each	28.0000	2	100			
<div> <div>Location</div> <div>GA</div> <div>66971</div> </div> <div> <div>Loc Qty</div> <div>28</div> <div>28</div> </div> <div> <div>Loc Code</div> <div>B67222</div> </div> <div> <div>78</div> <div>28</div> </div>													
D3065-7  Step Spacer		Manufactured	No			100	Each	59.0000	1	50			
<div> <div>Location</div> <div>GA</div> <div>66951</div> <div>67223</div> </div> <div> <div>Loc Qty</div> <div>59</div> <div>19</div> <div>40</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div> <div> <div>19</div> <div>34</div> </div>													

SB 11/03/23

SB 11/03/23

SB 11/03/23

SB 11/03/23

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, March 23, 2011 12:43:28 PM

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Work Order ID: 67503



Parent Item: D3065-041



Parent Item Name: Step Leg Assembly Hi

Start Date: 3/23/2011

Required Date: 3/24/2011

Start Qty: 50.00

Required Qty: 50.00

MS20470AD4-4

Purchased

No

100

Each

2,348.000

30

1500



SB 11/03/23

Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

2348

112314

30

113368

92

116188

642

116391

1584

1590

W/O:		WORK ORDER CHANGES					
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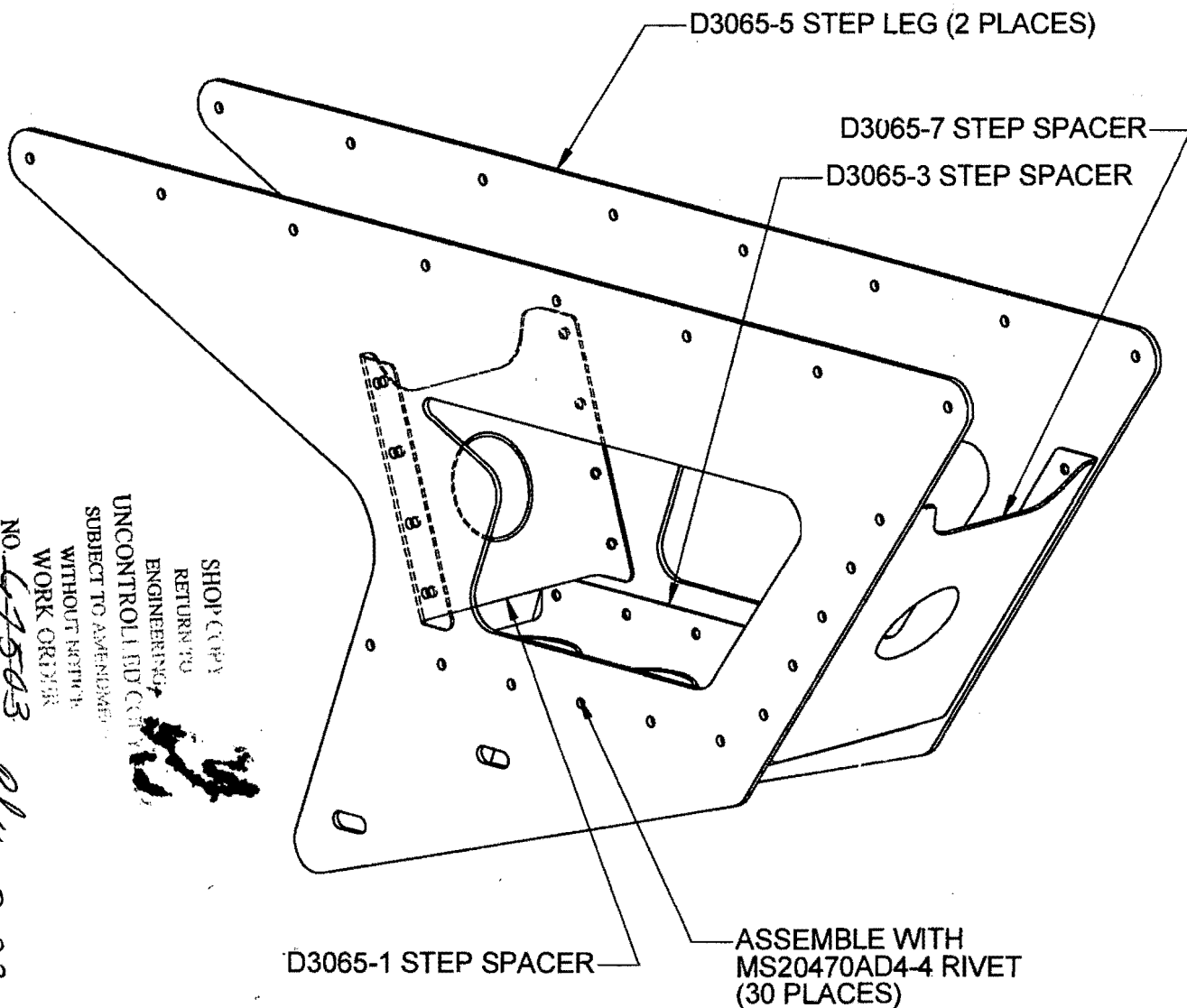
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06-06-20 *[Signature]*



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 64503

06/11-03-23

D3065-041 STEP LEG ASSEMBLY

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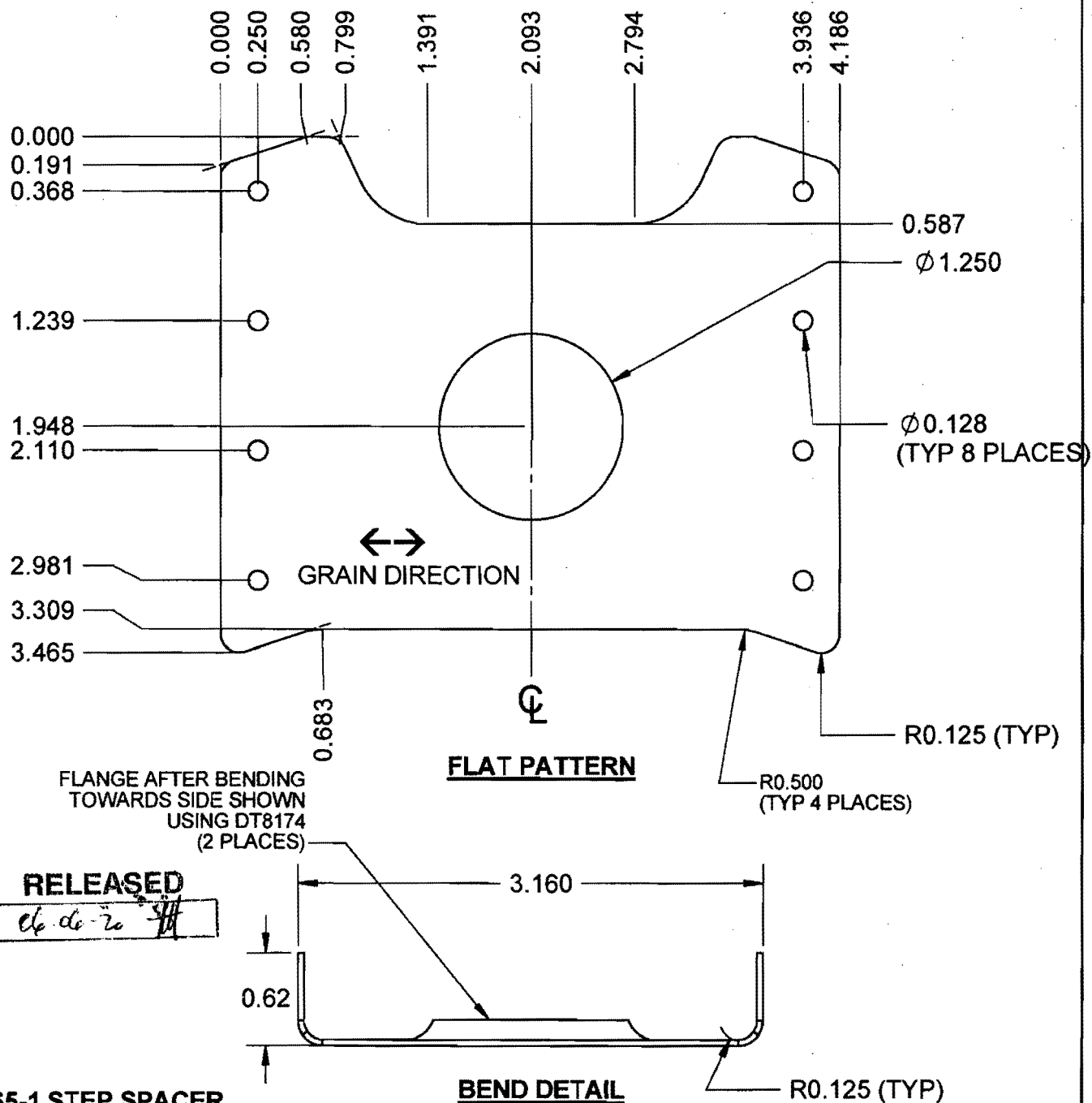
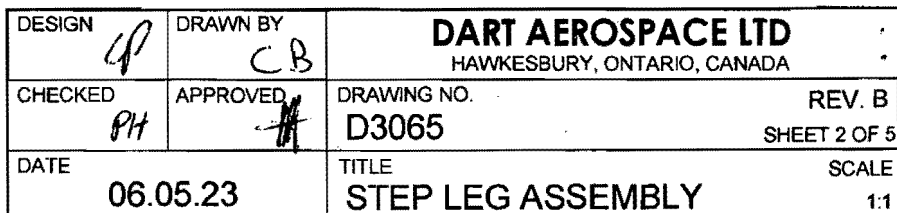
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NOTE: Date & initial all entries



D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
3) BREAK ALL SHARP EDGES 0.005 TO 0.010
4) PART IS SYMMETRIC ABOUT CENTERLINE
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

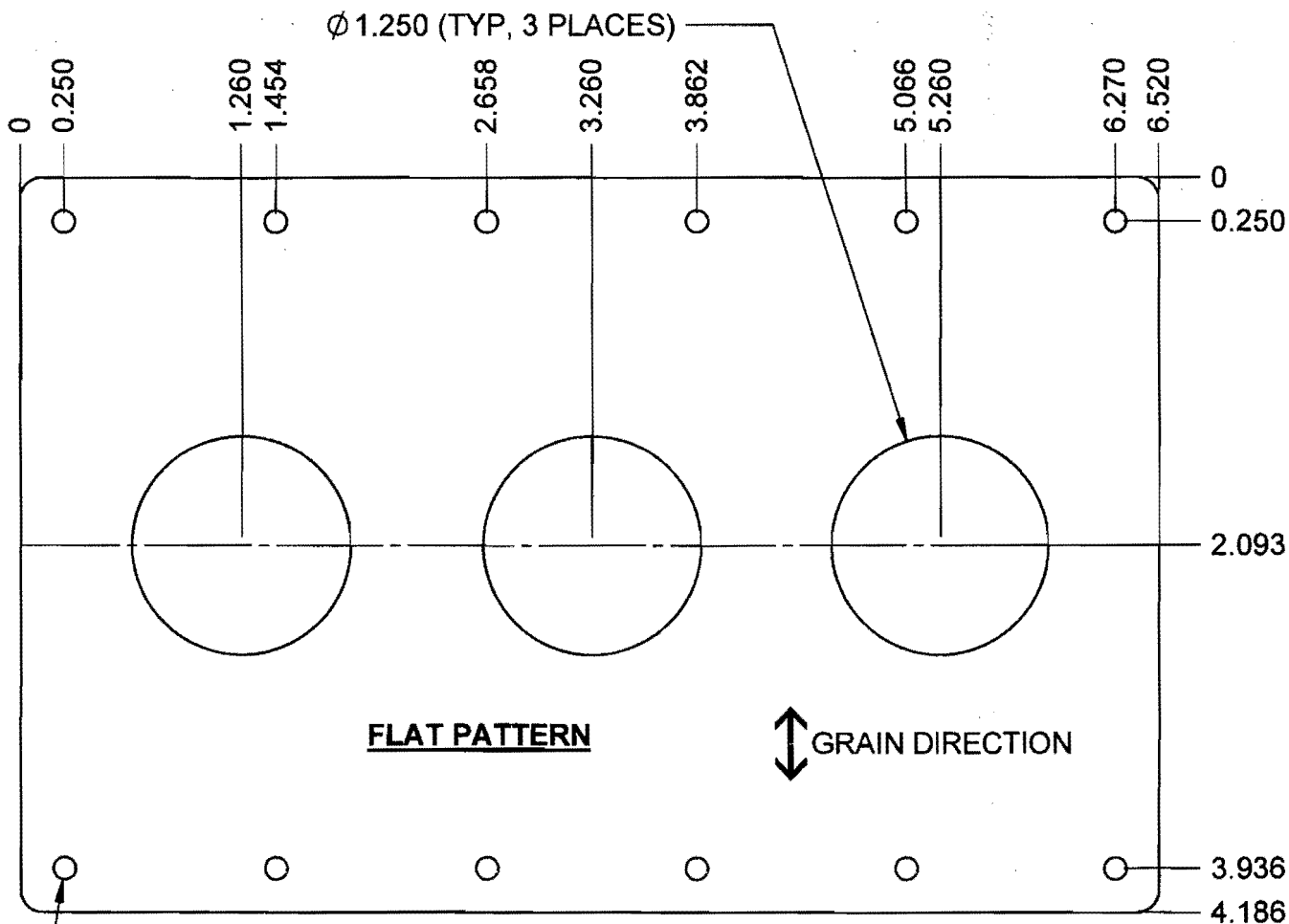
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NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

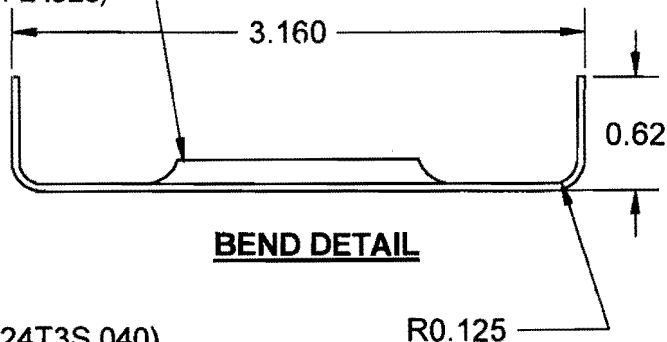


FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

RELEASED

06.06.20



D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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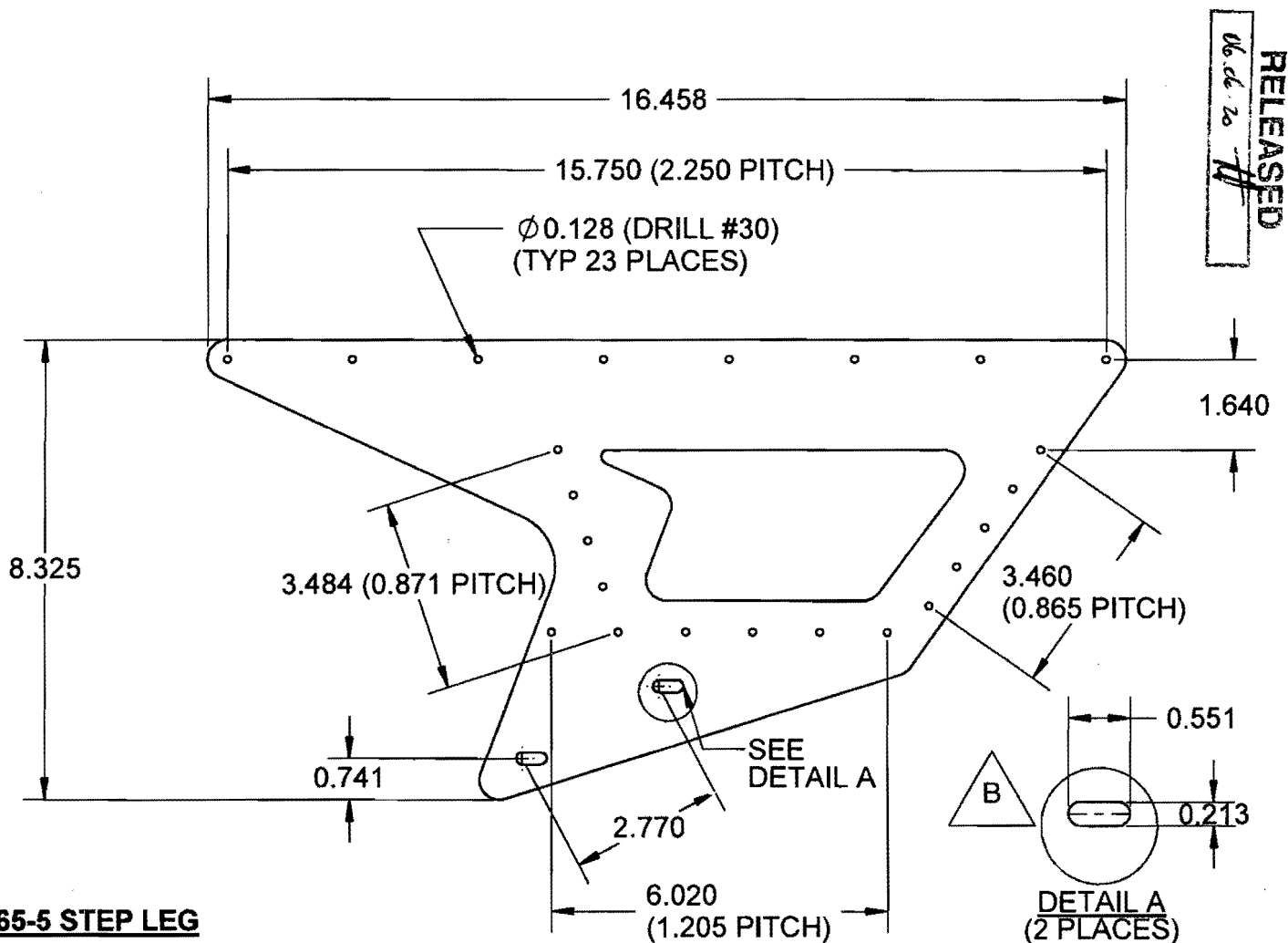
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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
06.05.23	CB	DRAWING NO.	REV. B
06.05.23	PH	D3065	SHEET 4 OF 5
DATE		TITLE	SCALE
		STEP LEG ASSEMBLY	1:3

**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
 - 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
 - 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
 - 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
 - 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 6) ALL DIMENSIONS ARE IN INCHES
- 46067503

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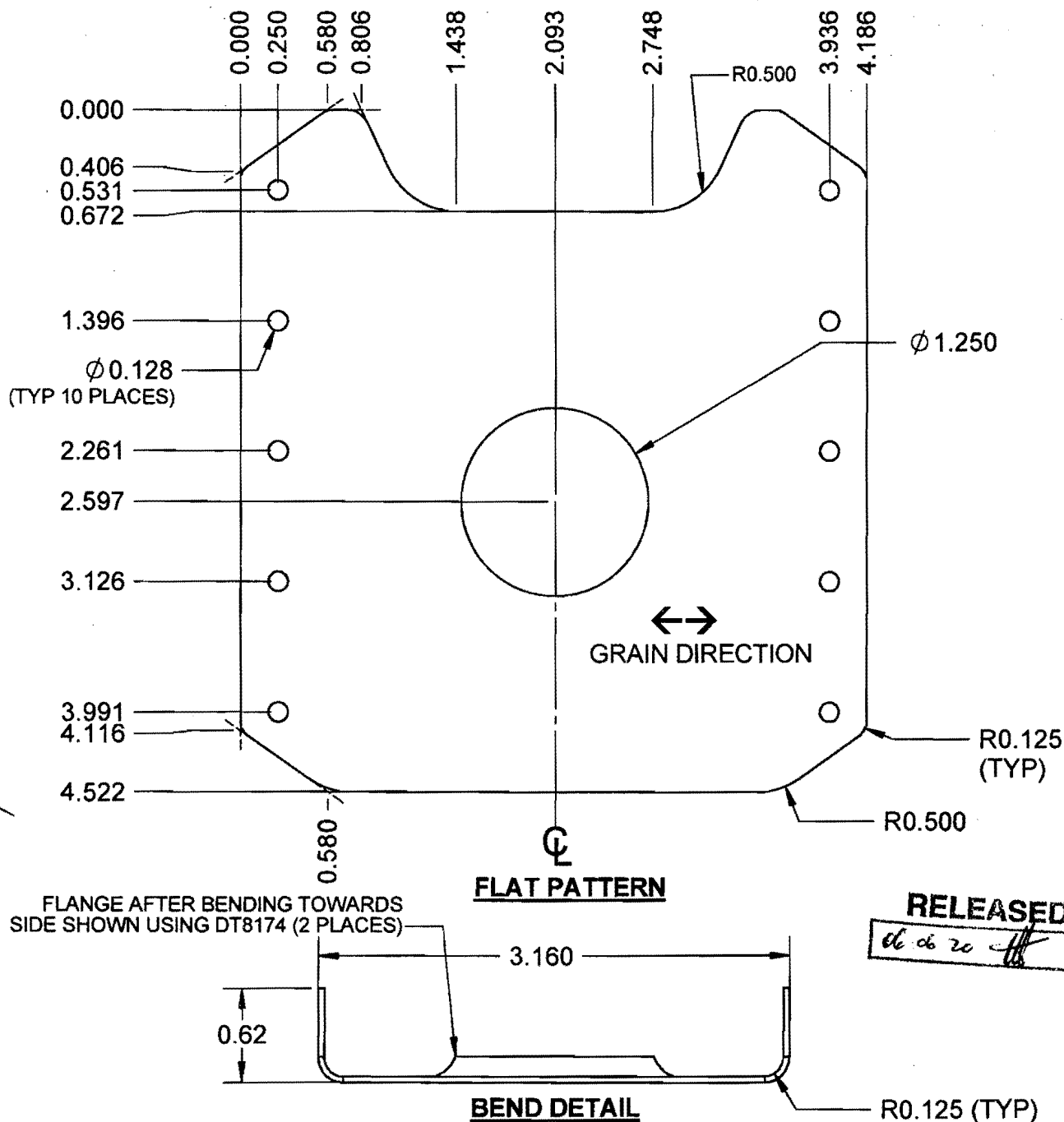
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DART

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

**D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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